

5/15

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	22568
<b>Description:</b> Step Leg	<b>Part Number:</b>	D3077-1
		D3170-1
<b>Dwg:</b> D3077 Rev. A1 <sup>RF 03.02.28</sup> A2 <sup>RF 03.02.28</sup> D3170 Rev. A	<b>Qty:</b>	20
		Page 1 of 1
		Stack of 10

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	EP	05.02.25	20
2	MV	Cut blanks: 12.100" x 5.070" (+0.030/-0.000) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17124 Identify as D3077-1	EP	05/03/22	20
3	MV	Cut blanks: 11.990" x 0.750" (-0.00/+0.010) Material: 5052-H32 (QQ-A-250/8) 0.080" thick (M5052H32S.080) Batch: M17124 Identify as D3170-1	EP	05/03/22	20
4	MV	Machine per Folio FA284 and Dwg D3077	EP	05/03/22	20
5	QC2	Inspect parts as they come off the CNC machine	EP	05/03/22	20
6	MV	Deburr to take measurement	EP	05/03/22	20
7	QC8	Second inspection	ML	05/03/22	20
8	MV	Machine per Folio FA282 and Dwg D3170	EP	05/03/22	20 Pto
9	QC2	Inspect parts as they come off the CNC machine	EP	05/03/22	20
10	MV	Deburr to take measurement	EP	05/03/22	20
11	QC8 & 5	Second inspection	ML	05/03/23	20
12	GA	Deburr D3077-1 and D3170-1 stack	FF	05/04/04	20
13	FP	Acid etch and Alodine per QSI 005 4.1 D3077-1 and D3170-1	FF	05/04/04	20
14	QC5	Inspect work to Step 13	ML	05.04.04	20
15	GA	Identify and Stock D3077-1 and D3170-1	ML	05.04.07	20
16	AC	Cost / part 11.67	Sur	05.04.08	20
17	DC	Close W/O 11.67 Inspect Level 21	EP	05.04.13	20

Rev	Date	Change	Revised By	Approved
A	02.10.11	New issue	KJ	
B	02.11.18	Incorporated D3170-1 IPP	KJ	

RELEASED  
02-11-20 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
03/02/22	#8	First stack moved during milling <del>Part</del> No. As Site	<i>JB</i> per 503-24	Scrap & 10 replace	<i>En</i> 05/03/22	<i>JB</i> 0503-24	<i>JB</i> per 503-24	<i>JB</i> 0503-24

Part No: D3077-1 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: *LD* Date: 05/04/22

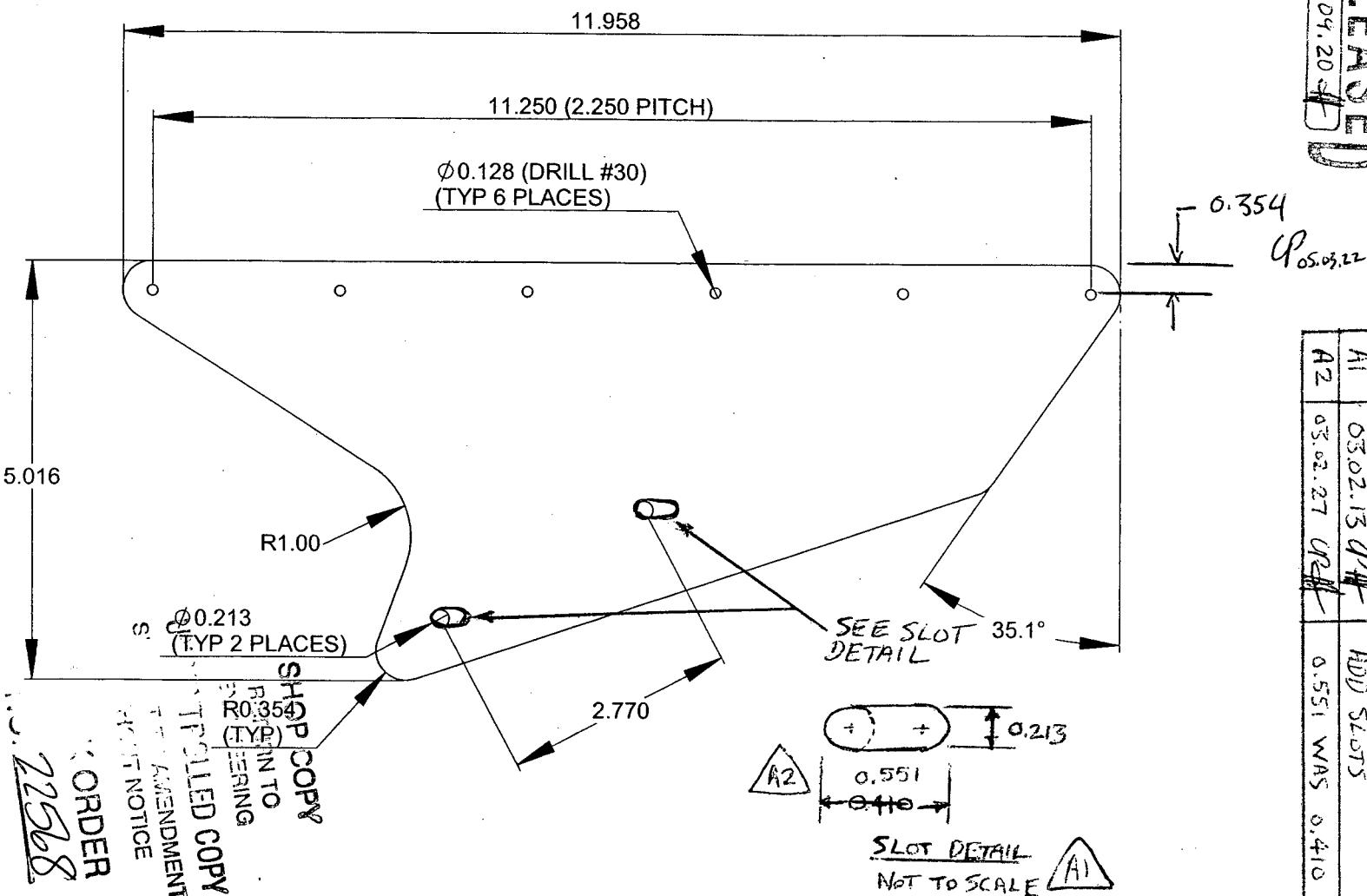
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



RELEASED  
02.09.2011

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	CP	REV. A
DATE	02.09.11	TITLE	D3077 STEP LEG	SHEET 1 OF 1
A	02.09.11	NEW ISSUE		SCALE 1:2
A1	03.02.13	ADD SLOTS		
A2	03.02.27	0.551 WAS 0.410		



### D3077-1 STEP LEG

- 1) MACHINE PER DWG FILE "D3077-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

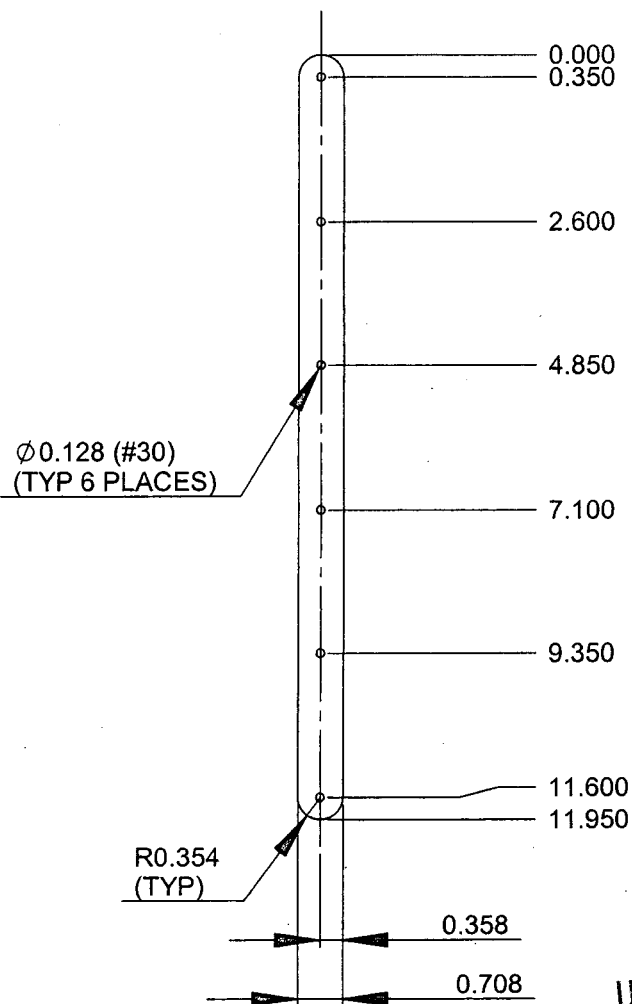
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DESIGN CP	DRAWN BY CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. <b>D3170</b>	REV. A SHEET 1 OF 1
DATE <b>02.09.11</b>		TITLE <b>SPACER</b>	SCALE 1:3
A	02.09.11	NEW ISSUE	

RELEASED  
02.09.20 [Signature]



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22568

### D3170-1 SPACER

- 1) MATERIAL: 5052-H32 (QQ-A-250/8) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Feb 24, 2005  
03:25 pm

Work Order No : 0022568  
Project Name : D3077-1  
Project For : WK515  
Work Order Type : Main  
Main WO Number :  
House Part Number : D3077-1  
Description : Step Leg  
Manufactured : Yes  
Amount Req'd : 20 u  
Amount Done : 0  
Start Date : 02-24-05  
Est Finish Date : 03-30-05  
Act Finish Date :  
Drawings Req'd : No  
Ok for Approval :  
Approval Rec'd :

Department Code:  
Burden Flags : NNNNNNNN  
WO Status : Open  
Invoice State : Not Invoiced  
Invoice Date :  
Invoice Number :  
Invoice Amount : 0.00  
Order Entry No :  
OE Value : 0.00  
Est Margin : 0.000%  
Actual Margin : 0.000%  
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00



